ļ	er ID 119361 5, 2014 3:44:09 PM		*119361*								
Revision ID:	D3573-8 Adapter		Accept	*N900	040	100) * :	Setup Star Stop	17	S1* S2*	
Start Date: Required Date: Reference:	5/15/14 Start Qty: 10.0 5/15/14 Req'd Qty: 10.0			Cust Item 1 Customer:	ID:						
Approvals:	Process Plan: MLJ QC:	<u> </u>	Tooling: SPC (Y/N):		ate:		1	Run Star Stoj	, "I <i>A</i>	R1* R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3573	Rev A			•				,			
100 *1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	BAND SAW Memo		0.00				10			MH 14/05/26	
Jeaspa Bandsaw		k 3.500" long	0.00							14/05/26	
\$										•	
110			0.00								
110	HAAS CNC VERTIO	CAL MACHINING #1					10	_ <i>#</i>		MM	
HAAS 1 HAAS CNC vertical	Memo I machine #1 Machine	e as per Folio FA679 and Dwg I	0.00 03573							M/05/30	
120 *120*	QC2- Inspect parts o	ff machine FAI/FAIB	0.00					\sim		MM	
QC	Memo		0.00				10				

Memo

Quality Control

DQA:		Date:			•			_				DART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		ork Order up	odate only	AEROSPACE
Work Order:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update	Ţ	nitial	Acti	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
						FA	ULT CA	TEGORY				
Landing	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter sequence	e/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set Out of	tion Incomplete/Un tions Incomplete/U gned/off center eled d		Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	tolerance ct issing Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence	<u> </u>			

119361

Page 2

Thursday, May 15, 2014 3:44:09 PM D3573-8 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Adapter *10* **Start Qty: 10.00 Start Date:** 5/15/14 **Cust Item ID:** Required Date: 5/15/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start Date: Tooling: Approvals: Process Plan: Date: Stop QC: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp ml 14/05/30 130 QC8- Inspect parts - second check 0.00 *130* 0.00 Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 10 HB 146-2 *140* HandFinish 0.00 Memo Hand Finishing Grey Sandtex(Ref: 4.3, 5.6), per QS1005 4.3 150 0.00 10 8 14-6-2 333 *150* Powdercoat 0.00Powder Coating

DQA:			Date:			_								ADT
						WORK ORDER NON	-CO	ONFO	RMANCE / UF			-		AEROSPACE
QA Closed:			Date:							<u>\</u>	ork Order up	odate only		
Work Orde	ır.					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS		
Work Orac	-'' -					Rework	1		Skid-tube	Crosstube	7	Water Jet	☐ Fn	gineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1		noforming	Finishing	⊣	re/Packaging		Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite]	Supplier		
			1	· · · · · ·		<u> </u>					1			
Root					Desc	ription of work order update		Initial	Acti		Sign &	., .,.		
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification		QC Inspector
Design	4													
Doc/Data	\dashv													
Equip/Tooling	_													
Handling/Pre	\dashv													
Material	\dashv													
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport Unapproved														
Ollappioved			1	1	L		FA	ULT CA	TEGORY		ــــــــــــــــــــــــــــــــــــــ		ı	
Landir	ng G	iear				General						<u>-</u> -		
		Bending				Bend		Folio/F	Program	Γ	Outside Dim	ensions	Pres	sure/Forced
<u> </u>		Centre No	ot Concer	ntric		BOM/Route		Grain		-	Over/Under	tolerance	Set-	up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí	Tem	perature/Cure
, , ,	-	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld	d
		Cuffs	, , ,	•		Contamination		4 ·	tions Incomplete/U		Part Moved		Wro	ng Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	-		Power Loss/	Surge	Othe	er
]		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	-			Drill Holes		Off-set						
		Turning S				Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence					

Work Order ID	11936
Thursday, May 15, 2014	3:44:09 I

110261

Page 3

Thursday, May	15, 2014 3:4	14:09 PM		* 1 19.5D 1 **									1 450 5		
Item ID: Revision ID: Item Name:	D3573-8 Adapter			Accept	*N900	040	100)*	Setup	Start Stop		S1*			
Start Date: Required Date: Reference:	5/15/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:					TV.				
Approvals:	Process P	lan:	Date:	Tooling: _	Da	ate:			Run	Start	*NI	R1 *			
	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop	*NI	R2*			
Sequence ID/ Work Center II 160 *160* QC Quality Control 170 *170* Packaging Packaging	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stock	Location	Set Up/ Run Hours 0.00 27 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	1	Reject Number	Insp. Stamp			
180 *1 An* QC Quality Control		QC21- Final Inspection - W	ork Order Release	0.00				_ML	5	(\ ML3	196-e	06-02	{		

DQA:			Date:										TOAPT		
a			Data			WORK ORDER NON	-CO	ONFO	RMANCE / U		Vanis Ondan		AEROSPACE		
QA Closed:			Date:						*	<u> </u>	Vork Order up	date only			
Work Orde	er:		,			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
	,		Į.		_	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
				"		Use-as-is	1		noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	No.					Suspected Unapproved	1		Large Fab	Composite		Supplier			
												:			
Root					Desc	ription of work order update	1	Initial		tion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator					4										
Offset/Setup															
Process						, M									
Supplier						•									
Training		Į.													
Transport	_	•	ļ.								· (*)				
Unapproved	<u> </u>	<u>. </u>	1	<u> </u>]		ΕΛ	III T CA	TEGORY	· · · · · · · · · · · · · · · · · · ·		<u> </u>			
Landi	na (- ·				General	FA	OLI CA	ILGORI		41624				
Lanun		Bending			Ė	Bend	Ė	Teolio/F	Program	Γ	Outside Dim	r	Pressure/Forced		
		-	ot Concer	ntric		BOM/Route	\vdash	Grain	rogram.	<u> </u>	Over/Under	ł	Set-up		
	┝	Cracks	or concer	Terre		Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorre		Temperature/Cure		
	\vdash	Crimp/Ki	nk/Rinnle	/Wave	-	Burrs		4	ion Incomplete/U	ngualified	Part Lost/M	,	Weld		
		Cuffs	тутарыс	, wave	_	Contamination		-i `	tions Incomplete/	· ·	Part Moved	Ĭ	Wrong Stock Pulled		
	\vdash	Crushing				Countersink		4	gned/off center		Positioned V	، Vrong			
	_	Heat Trea				Cut Too Short		Mislab		ļ-	Power Loss/		Other		
	H	4	n Strip in	Tube		Drawing		Misrea		_	_	•			
		Marks/Cl				Drill Holes		Off-set							
	Г	-	Sequence			Finish		Out of	Calibration						
		-1	vist in Tub			Fit/Function		Out of	Sequence						

Thursday, May 15, 2014 3:44:12 PM

Work Order ID: 119361

119361

Parent Item:

D3573-8

D3573-8

Parent Item Name:

Adapter

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 10.00

**

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50		Purchased	No		100	f	29.0000	0.292	3.07368	4		

M6061T6B0 500X02 500

Loc Code Location Loc Qty MAT001 29

2 124443 - M126351 7 M128247 20

3.06 MM 14/03/26

DQA:			Date:											TART
						WORK ORDER NON	l-C(ONFO	RMANCE / UPDATI					AEROSPACE
QA Closed:			Date:			,				W	ork Order up	date only		
Work Order	٠.					DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS		
l	· –					Rework	7		Skid-tube Cros	sstube		Water Jet		Engineering
Part No	o.					Scrap	1)	all Fab	Pro	d. Eng. Coor.		Quality
	_					Use-as-is	1		У Щ	nishing		e/Packaging		Other
NCR No	o.					Suspected Unapproved	1		~ —	posite	·	Supplier		· 🗍
	_					in the second								
Root					Desc	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector
Design						•								
Doc/Data		1												
Equip/Tooling	_													
Handling/Pre	_								·		•			
Material	_													
Operator	_											i		
Offset/Setup	4						ŀ					:		
Process	_													
Supplier	_						1							
Training	4													
Transport	4													
Unapproved									FECORY					
							FA	ULT CA	TEGORY					
Landin	$\overline{}$				_	General]/_	Program		Outside Dim	oncions		Pressure/Forced
· -	_	ending	t Camaca		-	Bend BOM/Route	-	Grain	Togram	<u> </u>	Over/Under		\vdash	Set-up
<u> </u>		entre No Cracks	ot Concer	itric		Broken/Damage/Defect	\vdash	Hardwa	aro.	-	Part Incorre		_	Temperature/Cure
 	-		ık/Ripple	Maya	\vdash	Burrs	\vdash	4	ion Incomplete/Unqualifie	_{ed}	Part Lost/Mi		_	Weld
	_	Cuffs	ik) vibbie	/ wave	-	Contamination	-	- '	tions Incomplete/Unclear	 	Part Moved	JJ.11.6	Ь——	Wrong Stock Pulled
-	_	crushing			 	Countersink	\vdash	-1	gned/off center		Positioned V	Vrong	` لــــا	
-	_	leat Trea	t			Cut Too Short	-	Mislabe	-		Power Loss/	_	\Box	Other
			n Strip in	Tube	-	Drawing	-	Misrea		L.,	1		ـَــــــــــــــــــــــــــــــــــــ	
		/larks/Ch	-		一	Drill Holes		Off-set						
	_	urning Se				Finish		4	Calibration					
	_	_	ist in Tub			Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order: 11930	ol
Description: Adapter	Part Number: D357	73-8
Inspection Dwg: D3573 Rev: A	Page	1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

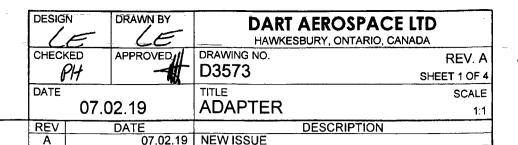
|--|

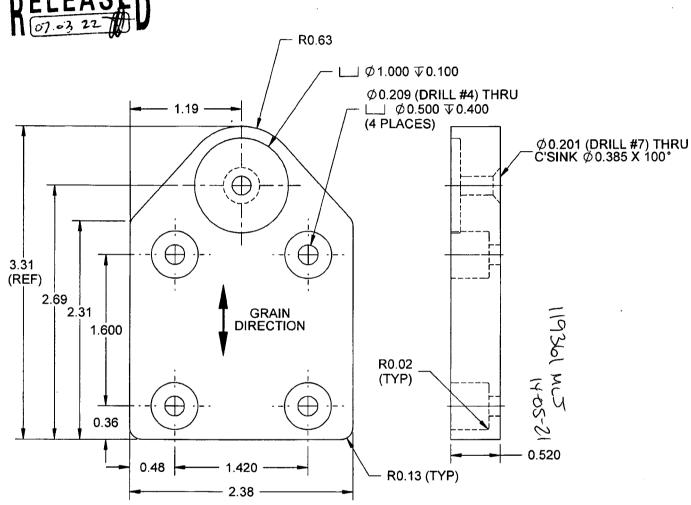
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.385	✓		174-04	Ca liper
2.75	+/-0.030	1.75				4
0.36	+/-0.030	-35	1			
1.600	+/-0.010	1.600	✓			
0.48	+/-0.030	. 478				
2.38	+/-0.030	2.378	\			
1.420	+/-0.010	1.420	J	-		
1.813	+/-0.010	1.810	>			
Ø0.209	+0.005/-0.001	016, 60%	1			
Ø0.201	+0.005/-0.001	.703	5			
Ø0.90 x 0.100	+/-0.010	.899 x .101	\			
Ø0.500 x 0.310	+/-0.010	.500 X.31c	۲.			
0.390	+/-0.010	.394	J			
Ø0.385'x 100°	+/-0.010 x 0.5°	- 385×10°	7		1	
R0.63	+/-0.030	-63	~		rad scase	
R0.13	+/-0.030	, 13	. 7		1	1
R0.02	+/-0.030	٠٥٦	۲			
			,			
					·	

Measured by: 1/4	Audited by:	and	Prototype Approval:	N/A
Date: いん/05/30	Date:	14/05/30	Date:	N/A

Rev	Date	Change	,	Revised by	Approved
Α	07.06.13	New Issue		KJ/JLM 🖈	E







D3573-1 ADAPTER

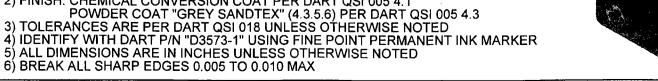
NOTES:

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

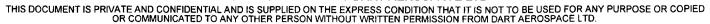
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



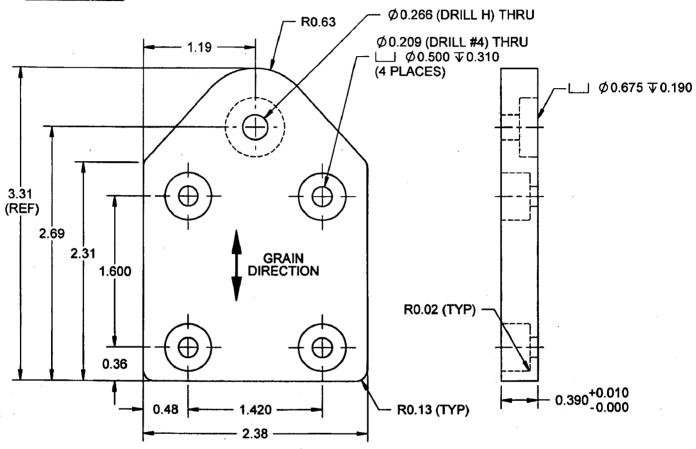






DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
PH	the	D3573	SHEET 2 OF 4	
07.02.19		TITLE ADAPTER	SCALE	
			1:1	

DELEASED OF 141.02 F



D3573-3 ADAPTER

NOTES:

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)

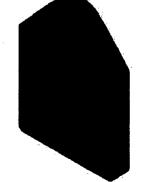
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

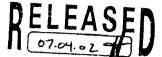
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

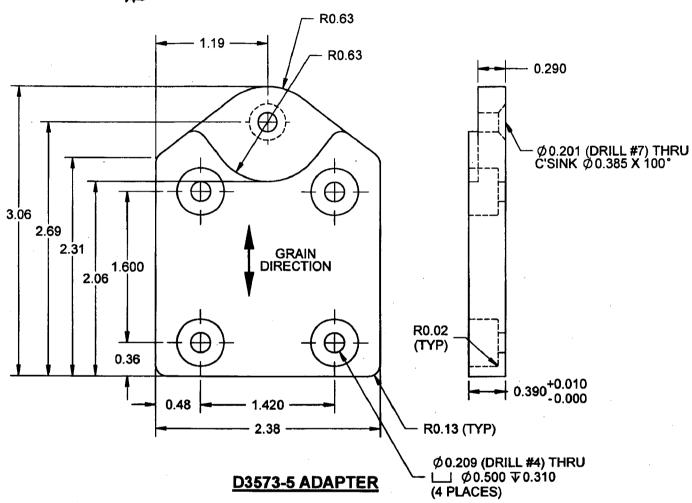


COPYRIGHT © 2007 BY DART AEROSPACE LTD



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
PH		D3573	SHEET 3 OF 4	
DATE		TITLE	SCALE	
07.0	2.19	ADAPTER	1:1	





NOTES: 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

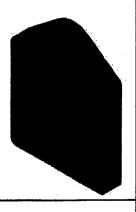
4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

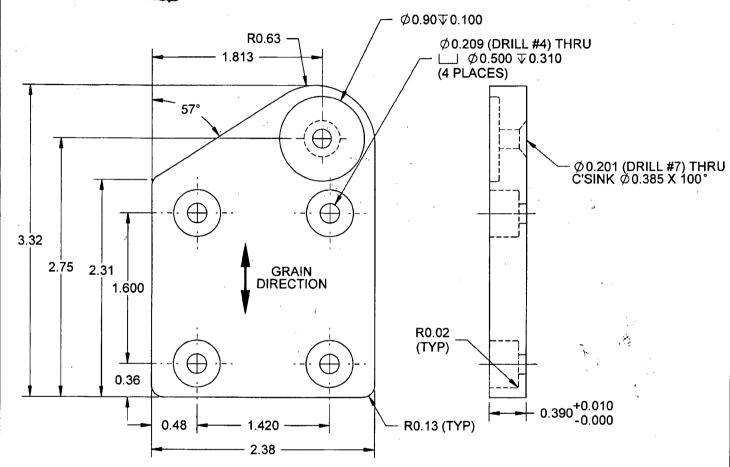


THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHECKED /	APPROVED /	DRAWING NO.	REV. A SHEET 4 OF 4
07.02.19		TITLE ADAPTER	SCALE 1:1



D3573-7 ADAPTER (SHOWN) **D3573-8 ADAPTER (OPPOSITE)**

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

